

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003040**Date Inspected:** 15-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2200**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Deck panels & PMT**Summary of Items Observed:**

Caltrans Quality Assurance Inspector Mr. David Kelsey (Caltrans QA Inspector) arrived at Shanghai Zhenhua Port Machinery Co (ZPMC) to observe the ZPMC Quality Control Inspectors noted below perform the duties and responsibilities as outlined in the Welding Quality Control Plan (WQCP), Contract Special Provisions and to randomly inspect the in-process welding fabrication at ZPMC fabrication facility for the Orthotropic Box Girder (OBG) and Tower bridge structural components.

This Inspector randomly performed in-process visual inspection on the GMAW process for tack welding & fit-up on the U-Rib segments to the OBG deck plate DP277A-001 in Bay#1. This Inspector randomly observed the ZPMC QC/CWI Mr. Chen Xi monitoring welding voltage, pre-heat & interpass temperatures & cleaning, weld pass width, root gap width, profile/size and travel speed per approved the approved WPS-B-T- 2342-U2 (GMAW).

This Inspector performed in-process visual inspection and monitoring of the production monitoring test (PMT) using the GMAW & SAW processes per WPS-B-T-2342-UI (urib)-3. This inspector monitored, recorded and sampled the PMTs for production run of DP566-001 & DP586-002. Initial 1st PMT appeared to comply with VT & UT. Samples were marked for each weld and thermal cut out for macro examination. Macro samples were examined by this inspector and found to be compliant with the Deck Panel Acceptance Criteria Dated 5-30-08. All results were recorded on PMT inspection sheet.

The in-process welding, fit-up & joint preparation observed by this Inspector appears to comply with the previously mentioned WPS in this report, the approved drawings, the WQCP, Contract Special Provisions and

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

AWS welding code D1.5 (2002).

No other observation took place during the shift by this inspector.



Item	Description	WBS	Dwg No.	Status
1	Picture above left Typical, CWI Chen Xi monitoring welding head parameters for a PMT on Gantry#1.			
2	Picture above right Typical, ZPMC UT technician Xue Hai Vang calibrating the UT instrument for PJP welds on the PMT.			

Summary of Conversations:

None noted

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry 858-344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Kelsey,David	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
